

# Work Order ID 74999

**\*74999\***

Page 1

Friday, October 14, 2011 2:49:45 PM

Item ID: D3261-1 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Battery Case Tray  
 Start Date: 10/14/2011 Start Qty: 4.00 **\*4\*** Cust Item ID:  
 Required Date: 10/21/2011 Req'd Qty: 4.00 **\*4\*** Customer:  
 Reference:

Approvals: Process Plan: MF Date: 11-10-14 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_  
 Run Start **\*NR1\***  
 Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3261	Rev A2

100	FLOW WATER JET	0.00							
-----	----------------	------	--	--	--	--	--	--	--

**\*100\*** FLOW WATER JET  
 Waterjet Memo 0.00  
 FLOW CNC Waterjet 1-Cut as per Dwg D3261 Dwg Rev: A2 Prog Rev: A2 2-  
ultra 750 Debur if necessary

110	HAAS CNC VERTICAL MACHINING #1	0.00							
-----	--------------------------------	------	--	--	--	--	--	--	--

**\*110\*** HAAS I  
 HAAS CNC vertical machine #1 Memo 0.00  
 1- Mill as per Folio FA421 Rev: A2 & Dwg D3261 Rev: A 2-Debur  
 per dwg D3261

120	QC2- Inspect parts off machine FAI/FAIB	0.00							
-----	---	------	--	--	--	--	--	--	--

**\*120\*** QC Memo 0.00  
 Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**\*74999\***

Friday, October 14, 2011 2:49:45 PM

**\*N900040100\***

Setup Start **\*NS1\***

Stop \*NS2\*

**\*4\***

**\*4\***

**Reference:**

Run Start \*NR1\*

Stop **\*NR2\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

0.00

**\*130\***

QC

## Memo

0.00

140

Identify as per dwg & Stock Location: 144

0.00

\*140\*

### Packaging

## Memo

0.00

## Packaging

150

QC21- Final Inspection - Work Order Release

0.00

**\*150\***

QC

## Memo

0.00

## Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Friday, October 14, 2011 2:49:44 PM

Page 1

Work Order ID: 74999

Parent Item: D3261-1

Parent Item Name: Battery Case Tray

Start Date: 10/14/2011

Required Date: 10/21/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP B04.12.02Material no longer cut in-houseKJ/JLM  
IPP Rev:C 08-11-21 Material cut On Waterjet JLM Verified BY:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MUHMWB750 UHMW .750 sheet		Purchased	No			100	sf	8.0000	1.9	8			

Location

MAT018

109986

Loc Qty

8

8

Loc Code

~~B111-1~~

109986

4

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 74999
<b>Description:</b> Battery Case Tray (Dual Battery Rack)		<b>Part Number:</b> D3261-1
<b>Inspection Dwg:</b> D3261	<b>Rev:</b> A2	<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
22.00	+/-0.030	22.00	✓		FK-05	Tape
18.00	+/-0.005	18.00	✓		"	"
12.25	+/-0.030	12.25	✓		"	"
9.75	+/-0.030	9.75	✓		"	"
1.27	+/-0.030	1.254	✓		FK-04	Vern
11.00	+/-0.030	11.00	✓		FK-05	Tape
Ø0.191	+0.005/-0.001	.191	✓		FK-04	Vern
0.50	+/-0.010	.505	✓		"	"
0.49	+/-0.03	.49	✓		"	"
2.00	+/-0.010	1.980	✓		"	"
10.00	+/-0.010	10.00	✓		FK-05	Tape
1.00	+/-0.010	1.005	✓		FK-04	Vern
2.13	+/-0.010	2.130	✓		"	"
Ø0.386	+0.005/-0.001	.386	✓		"	"
4.00	+/-0.005	4.00	✓		"	"
0.75	+/-0.030	.75	✓		"	"
0.125	-0.010/+0.030	.145	✓		"	"
0.55	+/-0.030	.55	✓		"	"
0.50	+0.000/-0.030	.485	✓		"	"
0.67	+0.000/-0.030	.67	✓		"	"

<b>Measured by:</b> FK
<b>Date:</b> 11/12/10

<b>Audited by:</b> [Signature]
<b>Date:</b> 11/12/12

<b>Prototype Approval:</b>	N/A
<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	04.07.07	New Issue	KJ/JLM	
B	04.12.06	Dimension 0.49 +/-0.010 was 0.610 +/-0.03	KJ/JLM	
C	08.11.27	0.67 dimension added	KJ/EC	[Signature]

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

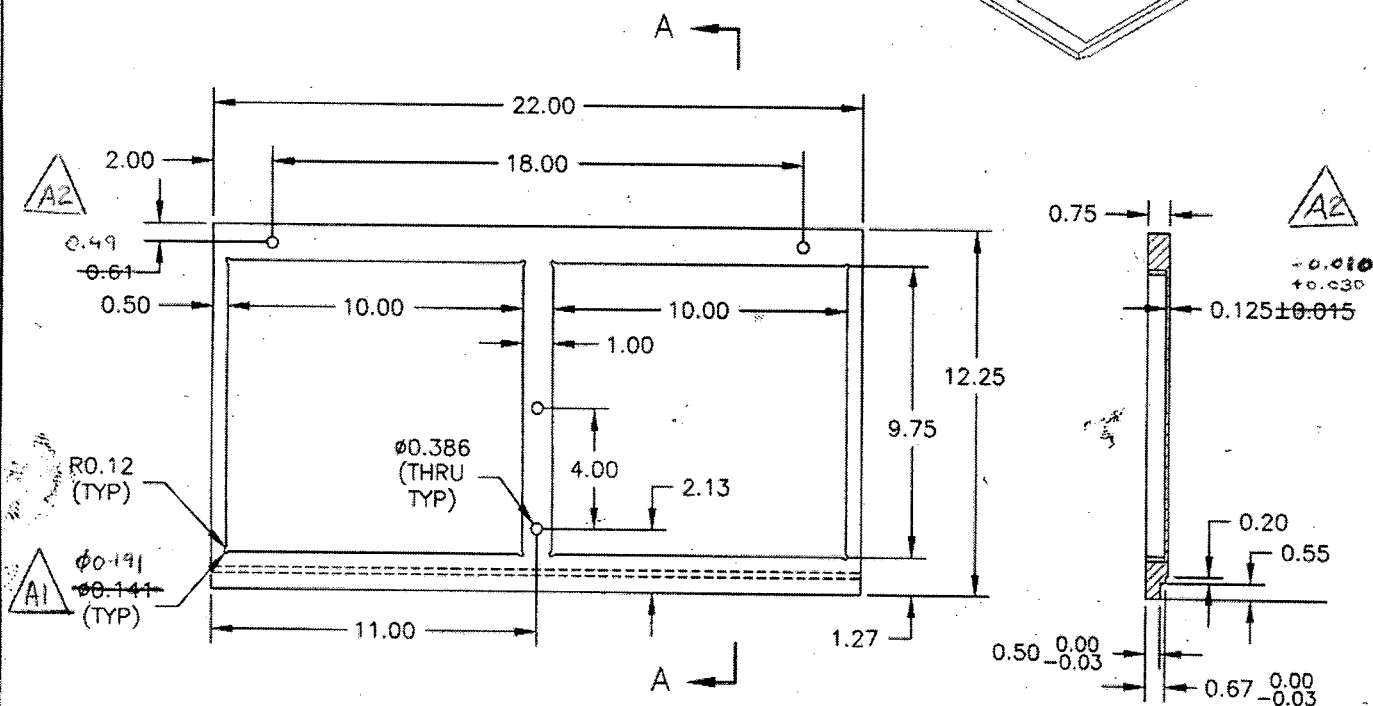
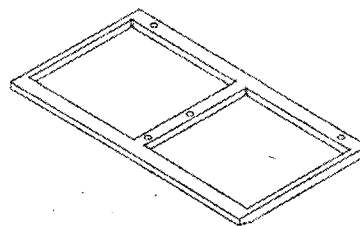
**NOTE:** Date & initial all entries





DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3261	REV. A SHEET 1 OF 1
DATE 04.04.06	TITLE BATTERY CASE TRAY		SCALE 1:6
A	04.04.06	NEW ISSUE	
A1	04.05.14	$\phi 0.191$ WAS $\phi 0.141$	
A2	04.06.08	$0.125 \pm 0.010$ WAS $0.125 \pm 0.015$ ; $0.49$ WAS $0.61$	

RELEASED  
04.04.27



UNDER REVIEW

D3261-1

SECTION A-A

04.04.05  
TOLERANCE CHANGE  
OK 04.10.27

NOTES:

- 1) MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES

Copyright © 2004 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries